

Work Order ID 135465

Wednesday, August 12, 2015 4:29:46 PM

135465

Page 1

Item ID: 646.3316

Revision ID:

Item Name: Blade

Start Date: 8/12/15

Start Qty: 4.00

4

Required Date: 8/12/15

Req'd Qty: 4.00

4

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: AUG 14 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.3300

N/C

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 6.000"

0.00

0.00

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB147

DWG REV: AA

FOLIO REV: N/C

0.00

0.03

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

4 0 15/09/23

4 0 15/09/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 135465

Wednesday, August 12, 2015 4:29:46 PM

135465

Page 2

Item ID: 646.3316

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 8/12/15 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 8/12/15 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00				4	0		15/09/03
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00				4	0		DAS 14 9-89 15/09/08
Quality Control									
140	Outsource process - Heat Treat	0.00							
140									
Outsource1	Memo	16.00							
Outsource process - Heat Treat	HEAT TREAT AS PER DWG, SEE NOTE #3								
	ISSUE P/O: <u>29729</u>								

CL **SEP 09 2015** 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 135465

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135465

Page 3

Item ID: 646.3316 Accept ***N1900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade
 Start Date: 8/12/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									DAS
Packaging	Memo	0.00							06 9-89
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							DAS
155									38 9-89
QC	Memo	0.00							
Quality Control									SEP 16 2015
160	Spray Painting per QSI005 4.2	0.00							DAS
160									41 9-89
SprayPaint	Memo	0.00							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: <u>131277</u>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Work Order ID 135465

Wednesday, August 12, 2015 4:29:46 PM

135465

Page 4

Item ID: 646.3316

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blade

Start Date: 8/12/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/12/15

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC14- Inspect Spray Paint

0.00

170

QC

Memo

0.00

Quality Control

DAS
38
9-89

SEP 21 2015

180

Identify as per dwg & Stock Location: GA

0.00

180

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

DAS
30
9-89

SEP 21 2015

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.01

Quality Control

SEP 21 2015

SH 20150921

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Wednesday, August 12, 2015 4:29:45 PM

Page 1

Work Order ID: 135465

135465

Parent Item: 646.3316

646 3316

Parent Item Name: Blade

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12/11/07 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased		No		100	f	142.4520	0.5	2.105263			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

hsp
15/09/03

Location

Loc Qty

Loc Code

MAT010

142.452

M126438

5.452

M127494

9

M131783

128

2,03'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER :																																																																				

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04765

SHEET 1 OF 1

DWG NO. 646.3300

REV: NC

PREPARED BY J. SOTO

DATE: 12/08/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

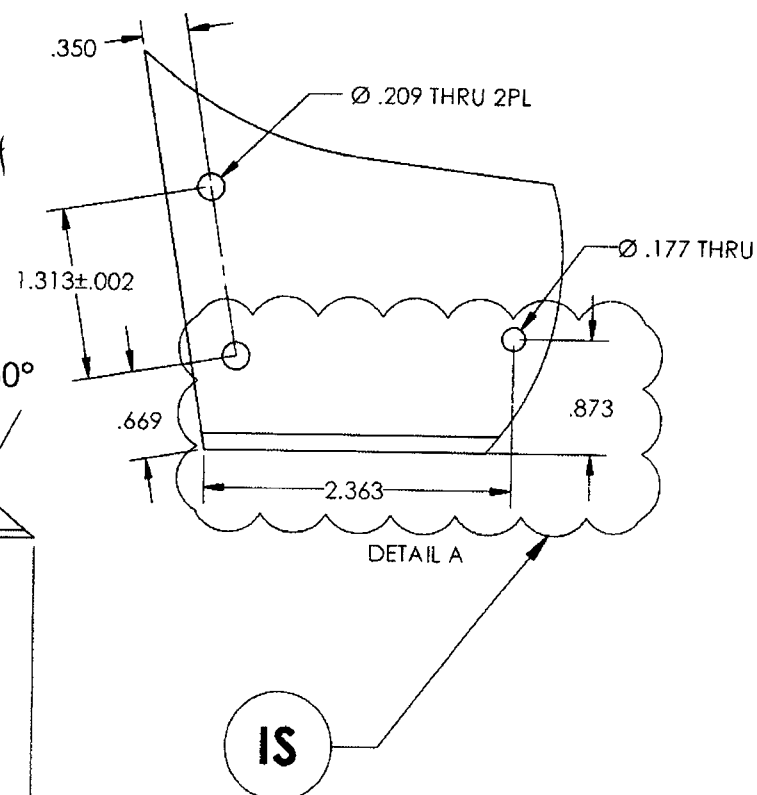
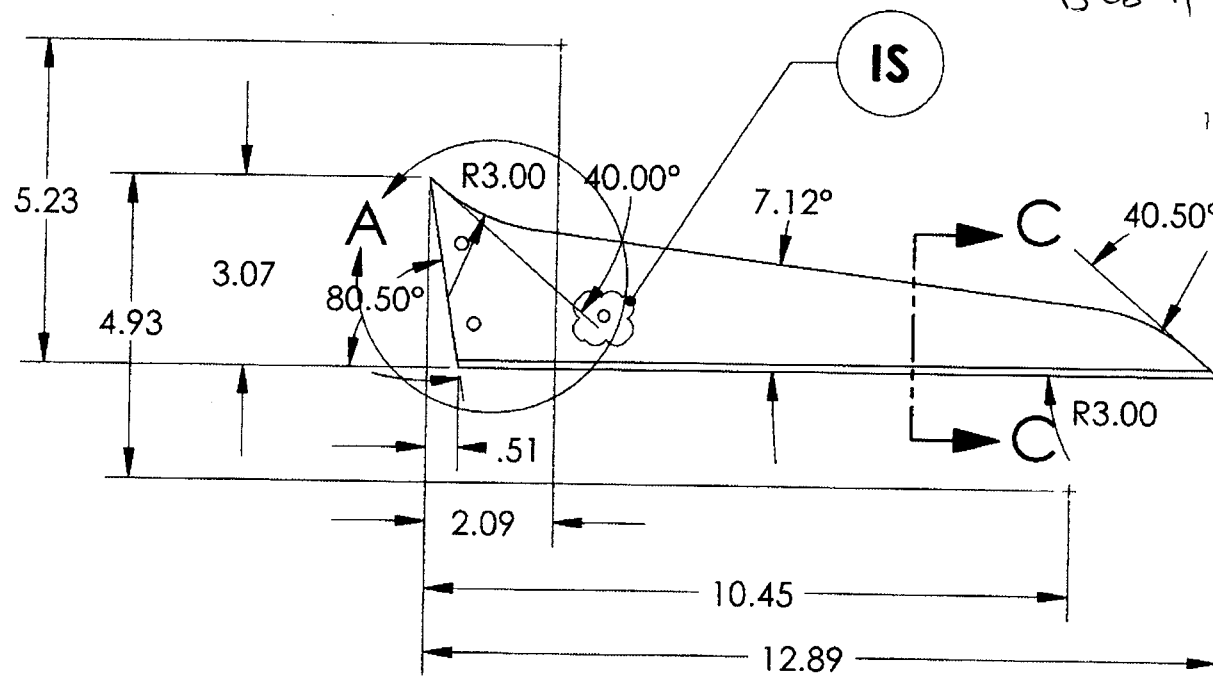
NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: ADDED HOLE DIMENSION TO 646.3313.

SHEET 5 IS:

STOP COPY
RETURN TO
THE ISSUING
OFFICE UNROLLED COPY
PERTAINING TO
THE ABOVE
MATTER
135465.MJ
1508-14



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03724

SHEET 1 OF 1

DWG NO. 646.3300

REV: N/C

PREPARED
BY B. PETERS

DATE: 12/05/12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

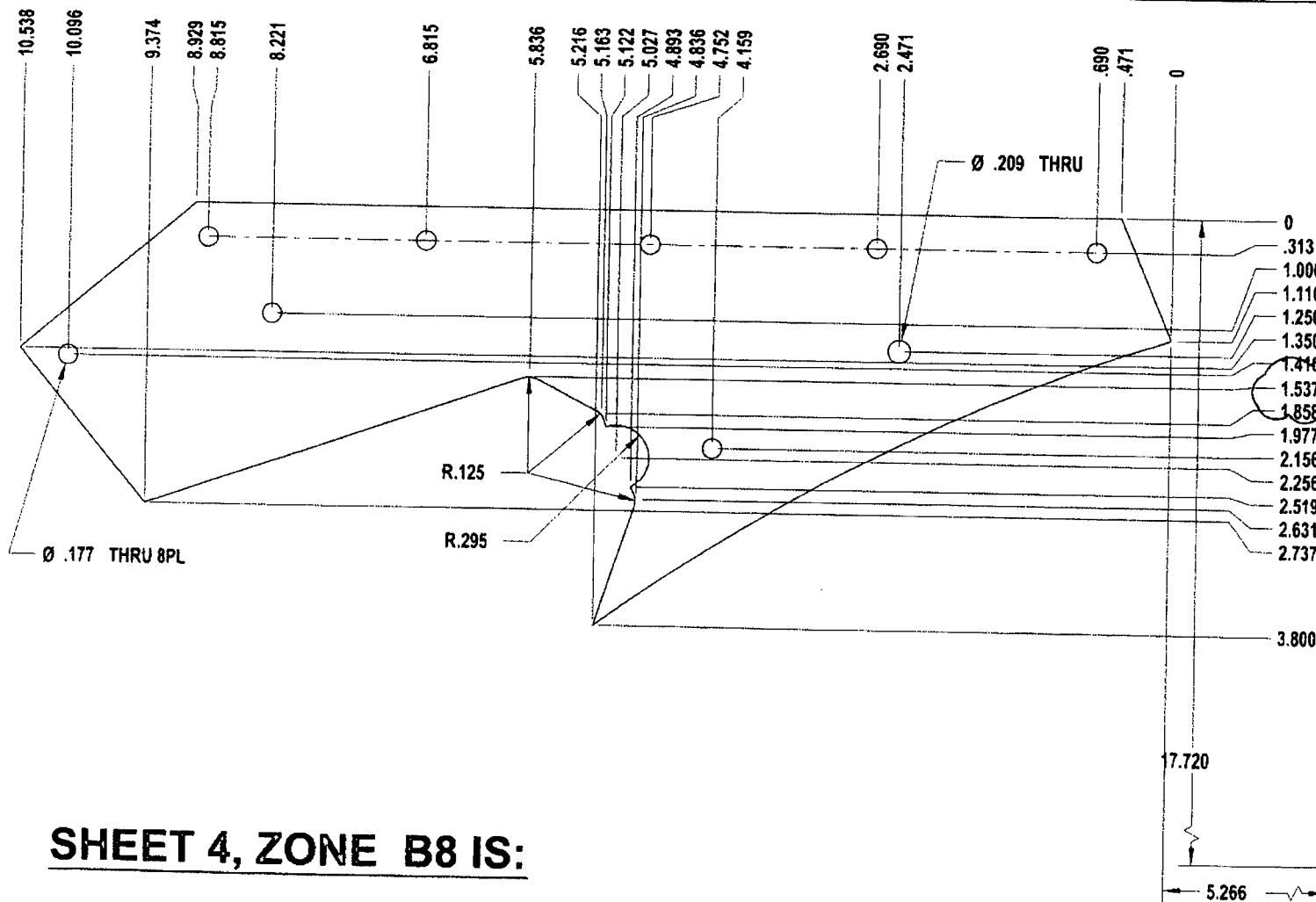
TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON:

REVISED ORDINATE DIMENSION.

ECR:

D-12-025



SHEET 4, ZONE B8 IS:

DOCUMENTS EFFECTED:

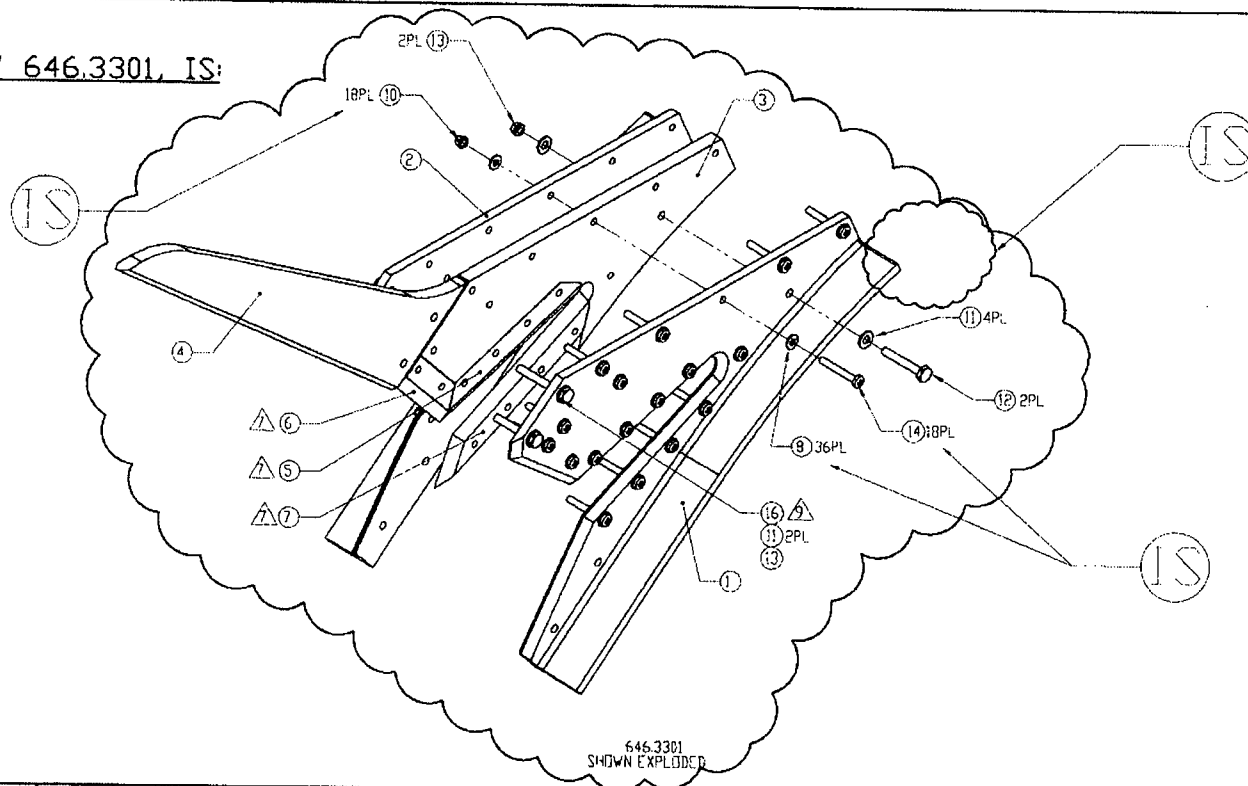
☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BDM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

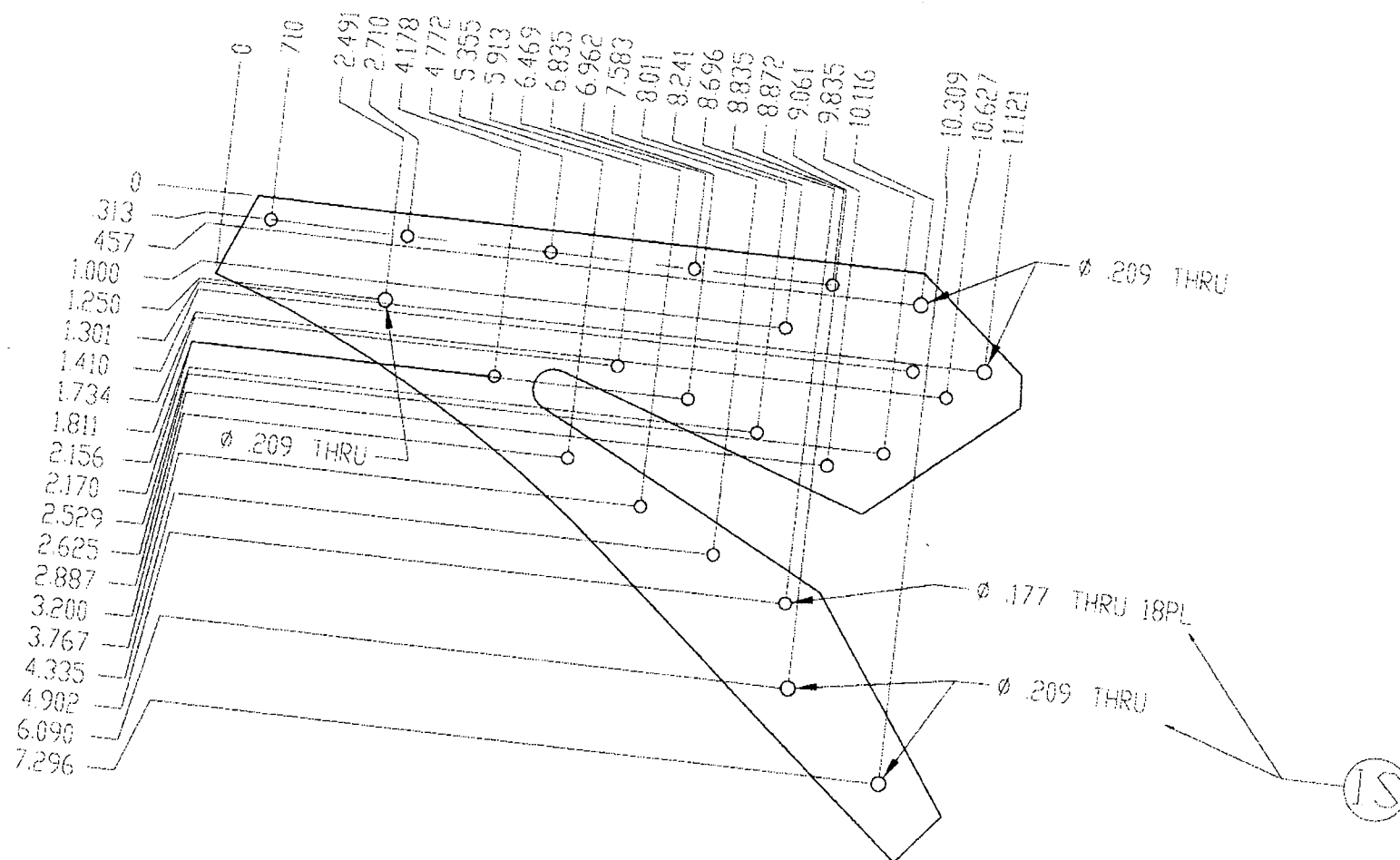
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02196		SHEET 1 OF 2	
	DWG NO. 646.3300	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
	EFFECT ON DWG ☐ INC. ☒ UNINC.			
DWG TITLE: UPPER CUTTER ASSY				
APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER	
REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS				
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE				

SHEET 1, VIEW 646.3301, IS:



14	R	601.2765		18	SCREW	MS27039-0819
10	R	601.1541		18	LOCKNUT	MS21042L08
9	D	601.2766		3	RIVET	MS20470AD5-18
8	R	601.2764		36	WASHER	NAS1149FN832P
				3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:						
☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM						
CHANGE CATEGORY					DER REVIEW REQUIRED	
☐ MAJOR ☒ MINOR					☐ YES ☒ NO	

SHEET 3, SECTION VIEW A-A, IS:

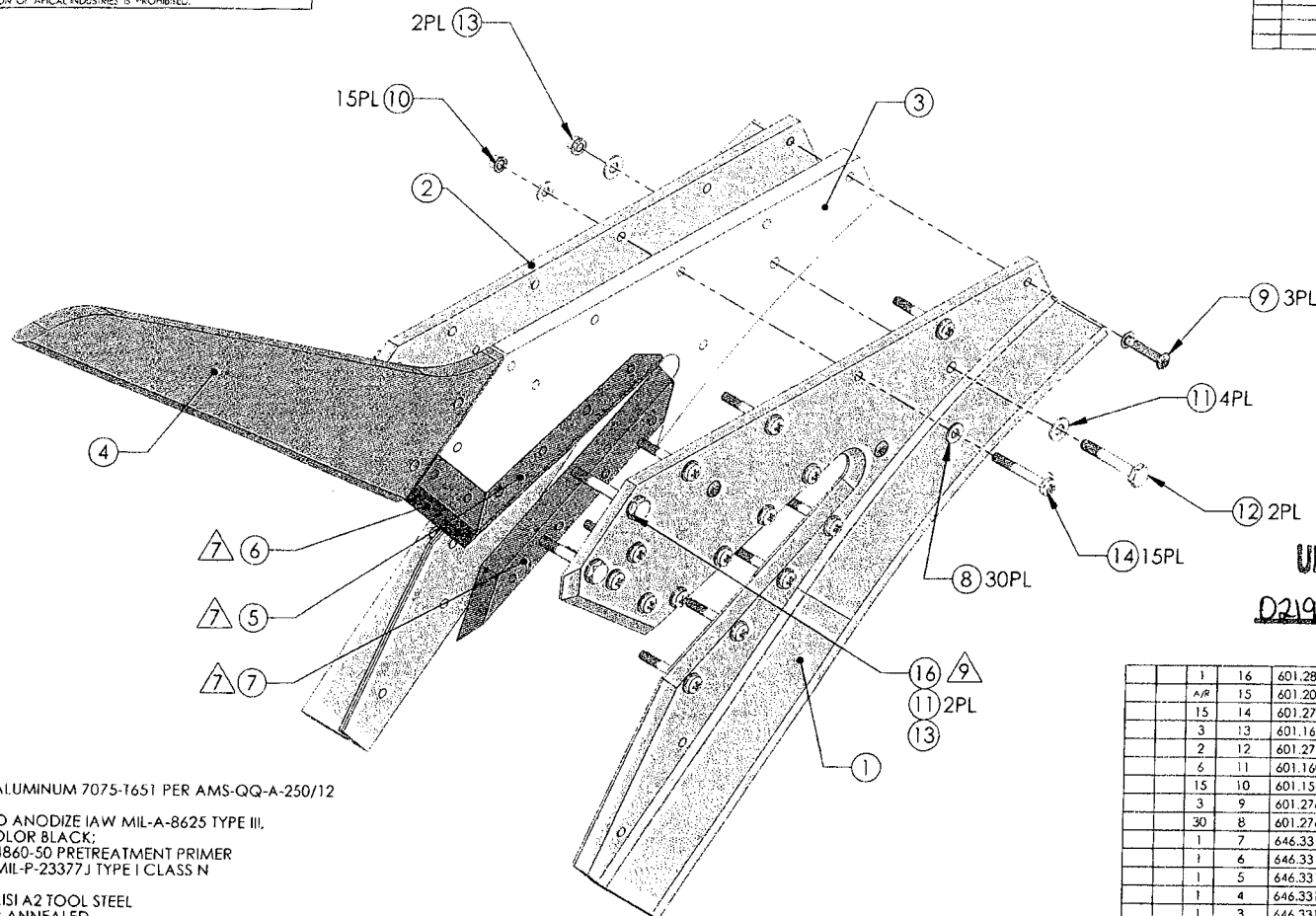


SECTION A-A

PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- 7 APPLY F/N 15 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5, 6 & 7 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 INSTALL FASTENER FINGER-TIGHT

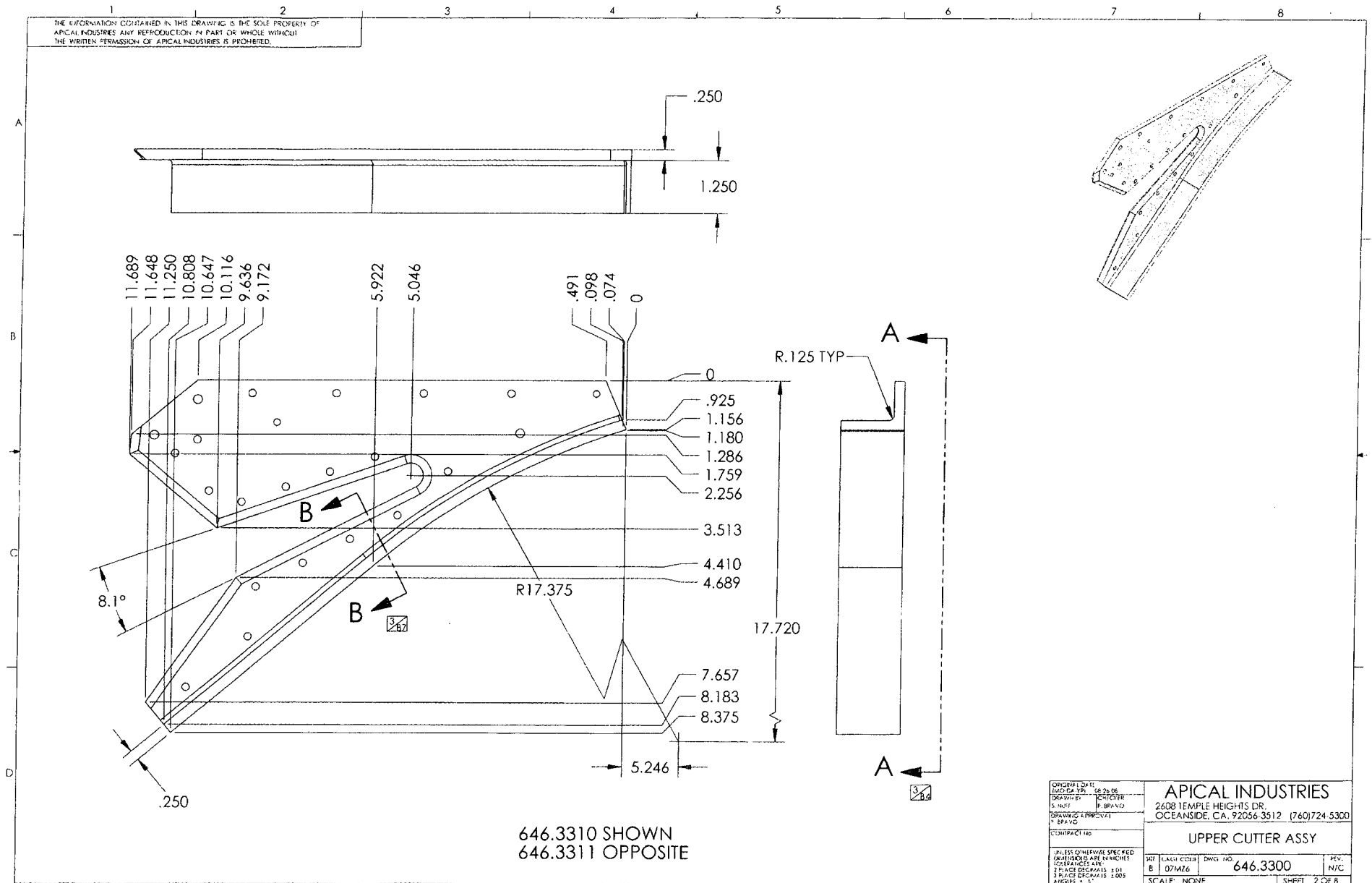
646.3301
SHOWN EXPLODED

UNINCORPORATED ECN(S)

02196, 03724, 04765

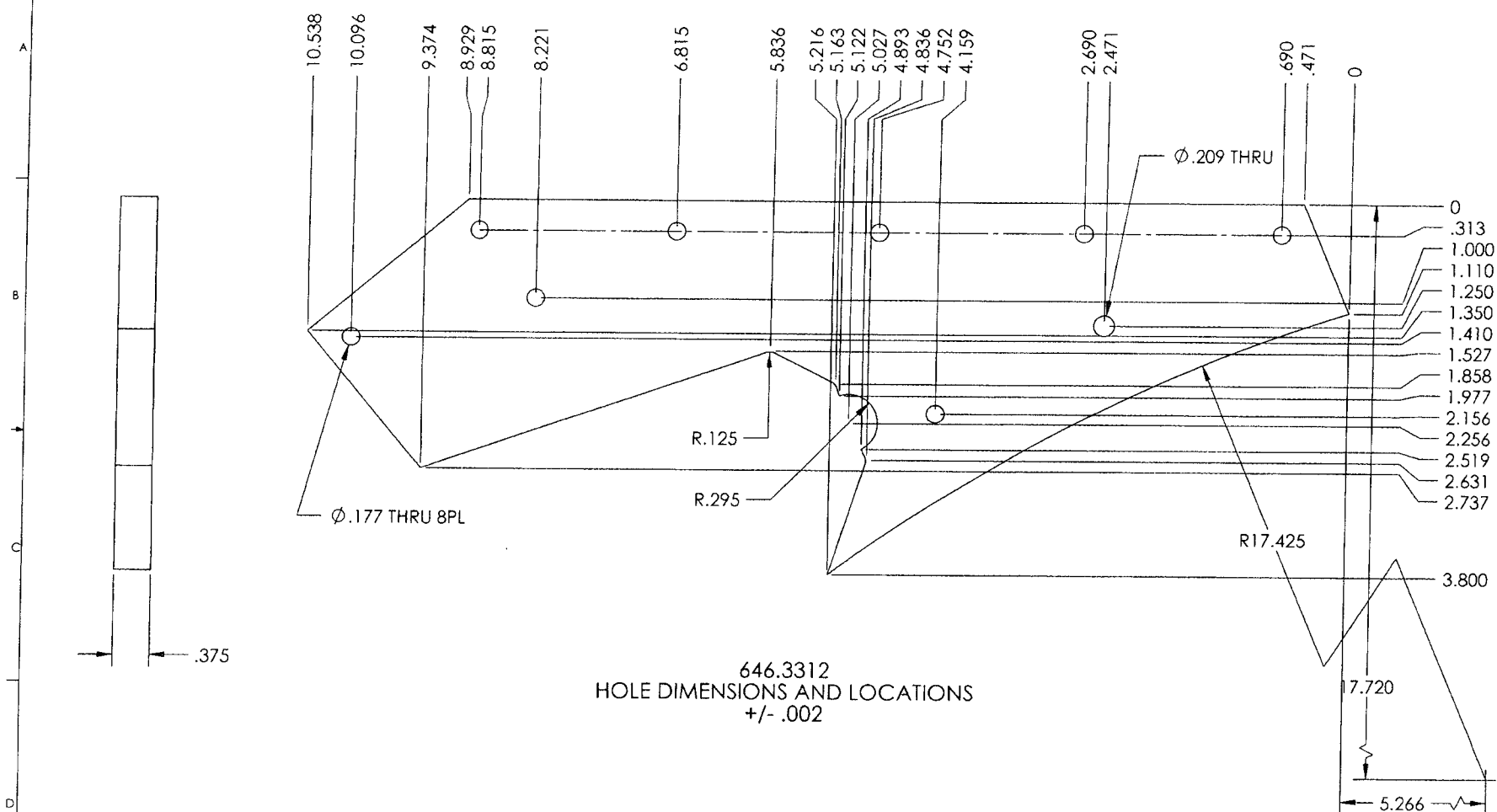
QTY	1	16	601.2834	BOLT	AND-16A	
	A/R	15	601.2045	RTV, LOCTITE 598		
	15	14	601.2765	SCREW	MS27039-0814	
	3	13	601.1624	LOCKNUT	MS21045L3	
	2	12	601.2763	BOLT	AND-12A	
	6	11	601.1607	WASHER	HA111490332P	
	15	10	601.1541	LOCKNUT	MS21045L3	
	3	9	601.2766	RIVET	MS20470A15-1R	
	30	8	601.2764	WASHER	HA111490332P	
	1	7	646.3316	BLADE		△
	1	6	646.3315	BLADE		△
	1	5	646.3314	BLADE		△
	1	4	646.3313	UPPER GUIDE		△
	1	3	646.3312	CENTER PLATE		△
	1	2	646.3311	RH HALF		△
	1	1	646.3310	LH HALF		△
			646.3301	UPPER CUTTER ASSY		
QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
PARTS LIST						
NEXT ASSY (S)			APICAL INDUSTRIES			
646.4000			2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
			UPPER CUTTER ASSY			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.005 ANGLES ±.5°			
			SHEET 1 OF 8			

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APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



ORIGINAL DATE 06/26/06		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY J. BRANCO		UPPER CUTTER ASSY	
CHECKED BY J. BRANCO		DATE 07/14/06	REV. N/C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ±.01 SURFACE FINISHES FINISHES ±.1		SCALE: NONE	SHEET 2 OF 8

DIVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

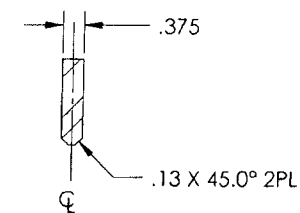
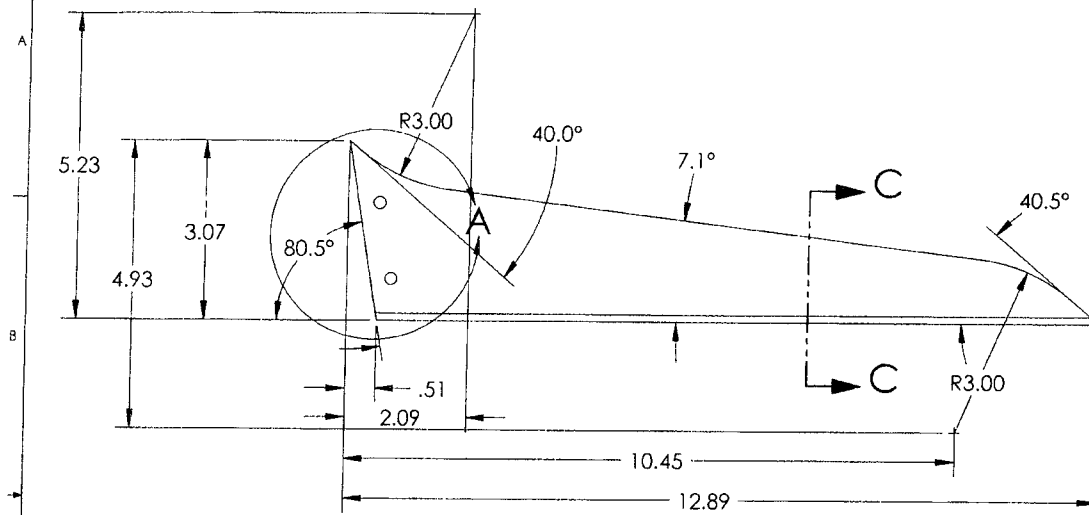


646.3312
HOLE DIMENSIONS AND LOCATIONS
+/- .002

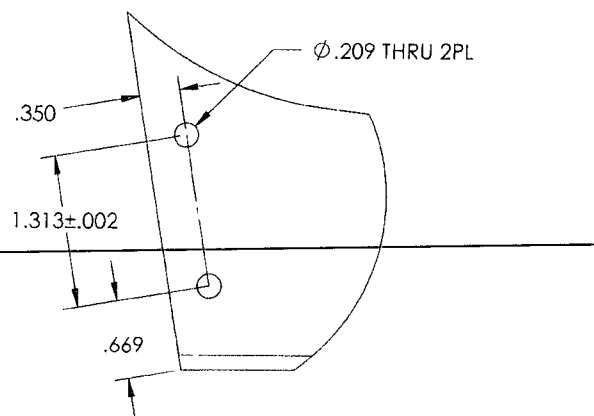
ORDER DATE 10-23-06	APICAL INDUSTRIES		
SHIPMENT BY AIR	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300		
QUANTITY APPROVAL 10-23-06			
CONTRACT #10			
UPPER CUTTER ASSY			
THREE CHINESE SPECIFIED DIMENSIONS ARE 2 INCHES SQUARE ARE 2 INCHES 1 PLECE DIMENSION 1.605 1 PLECE DIMENSION 1.605 1 PLECE DIMENSION 1.605			
REF	CAGL CODE	QWSG NO.	REV
8	07M26	646.3300	N/C
SCALE NONE		SHEET 4 OF 4	

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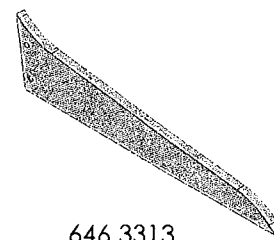
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



DETAIL A

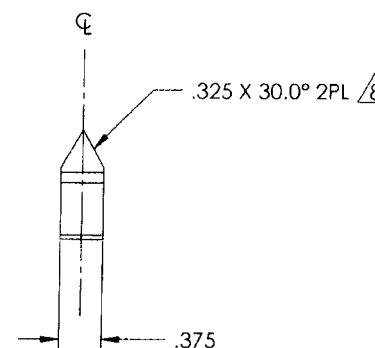
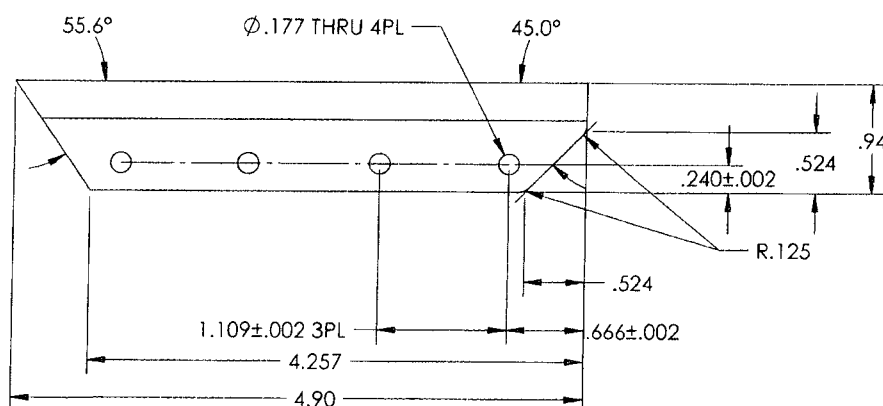
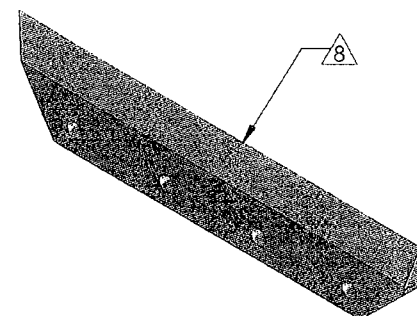


646.3313

ORIGINAL DATE: 06-26-08 DRAWN BY: S. HURF CHECKED BY: P. SPRAYO DRAWING APPROVAL: P. BRAVO DATE: 06-26-08 COMPLETION:	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS F TO 3 PLACE DECIMALS F TO ANGLES ± .5°	SHEET: B CAGE CODE: 07M25 DWG NO: 646.3300 REV: N/C SCALE: NONE SHEET 5 OF 6

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

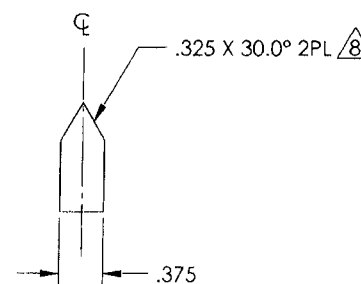
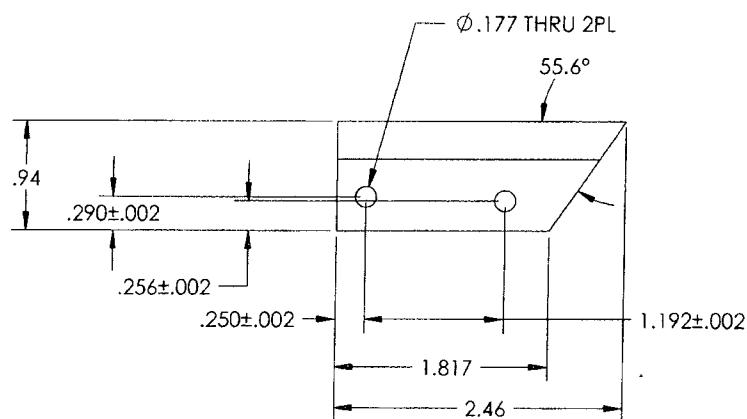
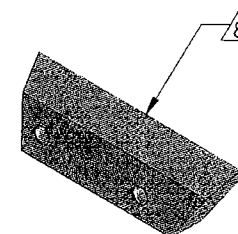


646.3314

ORIGINAL DATE: 06-26-06		APICAL INDUSTRIES	
DRAWN BY: CHECKED		2608 TEMPLE HEIGHTS DR.	
BY: HAD		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL		UPPER CUTTER ASSY	
BY: BRAVO		SCALE: NONE	
BY: BULLER		SHEET: 6 OF 8	
BY: CONTRACTOR		REV: N/C	
UNLESS OTHERWISE SPECIFIED		CAGE CODE: 646.3300	
DIMENSIONS ARE IN INCHES		DATE: 07/12/16	
TOLERANCES ARE:		SCALE: NONE	
FRACTIONS: 1/16		SHEET: 6 OF 8	
DECIMALS: .001		REV: N/C	
ANGLES: .5°		SCALE: NONE	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

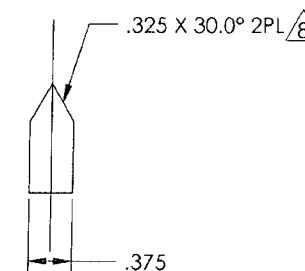
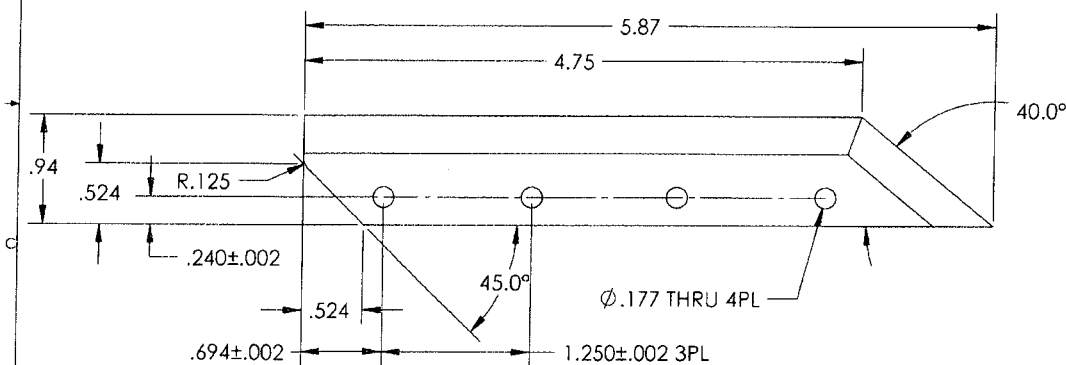
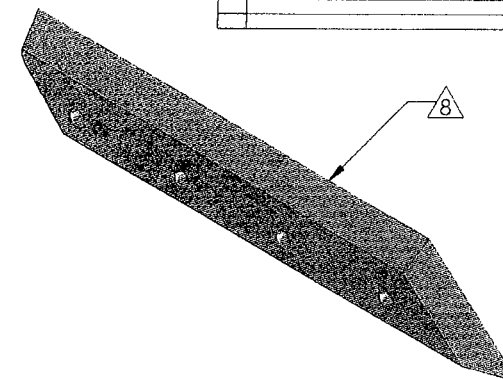


646.3315

DRAFTING DATE: 08-26-08 DRAFTER: J. HUFF DRAWING APPROVAL: P. BRAVO DESIGNED BY: J. HUFF CONTRACT NO.:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS: $\pm .01$ 3 PLACE DECIMALS: $\pm .005$ ANGLES: $\pm .5^\circ$		SHEET: B CASE CODE: 07M26 SNG. NO.: 646.3300	REV: N/C SCALE: NONE SHEET: 7 OF 8

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISION			
REV.	DESCRIPTION	DATE	APPROVED



646.3316

ORIGINAL DATE (DD-MY-YY) 08-26-08		APICAL INDUSTRIES	
DRAWN BY: S. KUFF		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BRAYO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: P. BRAYO		UPPER CUTTER ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ±.01 3 PLACE DECIMALS ±.003 ANGLES ±.5°		REV: B	REV: N/C
SCALE: NONE		SHEET 8 OF 8	

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Rapport d'Inspection**Inspection Report**

BON DE TRAVAIL order	CHARGEMENT load
304925	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
28728		A2		
VAC HARDEN		<u>SPECIFICATIONS DU PROCÉDÉ</u> processing specifications		
HARDEN AND TEMPER				
EXIGENCE / requirement	SPECIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	5	60 - 61 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
10	26,4	646.3316 (4) 646.3316 BLADE 135485 (6) 646.3315 BLADE 135584 1 BOITE DE CARTON		

/ 85000

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2015-09-13

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
304925	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
29729		A2		
VAC HARDEN HARDEN AND TEMPER		SPÉCIFICATIONS DU PROCÉDÉ processing specifications		
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62	HRC 5	60 - 61 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
10	26.4	646.3316 (4) 646.3316 BLADE 135465 (6) 646.3315 BLADE 135584 1 BOITE DE CARTON		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1:30 HR
DOUBLE TEMPER 400F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

APPROUVÉ par / Approved by:

Isabel Otero

QA Technician

DATE: 2015-09-14





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO29729

Purchase Order Date 9/9/2015

PO Print Date 9/9/2015

Page Number 1 of 2

Order From :

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

VC-MET004

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	135465	646.3316 BLADE	9/21/2015 Yes 9/21/2015		4.00	\$0.00	\$0.00
	FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED						
Line Total:							\$0.00
2	135584	646.3315 BLADE	9/21/2015 Yes 9/21/2015		6.00	\$0.00	\$0.00
	FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED						

15/9/16
SD

Note:

9/9/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29729**

Purchase Order Date 9/9/2015

PO Print Date 9/9/2015

Page Number 2 of 2

Order From :

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

VC-MET004

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Total: \$0.00

Line	Item Description	Quantity	Unit Price	Total Price
3	71401-45 PROCUREMENT QUALITY CLAUSES	1.00	\$0.00	\$0.00

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A020 non-destructive test/inspection identification
A021 dart aerospace processing
A024 process certifications
A026 certification of material conformance

No
9/21/2015

Line Total: \$0.00

PO Total: \$0.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 9/9/2015

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉ Shipper
304925	1	105060

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
29729		A2	2015/9/10	fed
QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight

10 646.3316

(4) 646.3316 BLADE 135465

(6) 646.3315 BLADE 135584

12/9/16
SP

26,4

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EMPAQUETAGE Packing		
------------------------	--	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 10

POIDS EXPÉDIÉ / Weight Shipped : 26,40

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 10